

Date: Thursday, 12/13/2007 11:23:51 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE KIT
 Job Number : 36308
 Estimate Number : 10532
 P.O. Number :
 This Issue : 12/13/2007 S.O. No. :
 Prsht Rev. : NC Part Number : K10003
 First Issue : / / Type : SMALL /MED FAB Drawing Number : IIN D205-634 REV D
 Previous Run : 36307 Project Number : N/A
 Material :
 Due Date : 1/12/2008 Qty: 8 Um: Each
 Written By :
 Checked & Approved By : AS 07.12.13
 Comment : Est: 03.01.16 Reformat: Incorporated D205-641-011
 KJ/RF
 Est: J 06-07-25 As per DSI 9344
 JLM
 Est: K 06.11.17 Per K10003 Rev C
 KJ
 Est Rev: L 07.01.12 Document Record for copying bluefile rmv
 KJ

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
 Create White labels only per PPP K10003 CHG 005

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

3.0 D2570 Bushing



Comment: Qty.: 24.0000 Each(s)/Unit Total : 192.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description	Batch
24	D2570	Bushing	36480

AS 08/02/08 (x8)

4.0 D2571 Saddle, Fwd, Out



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Saddle, Fwd, Out

Pick:

Qty	Part Number	Description	Batch
1	D2571	Saddle	3593147 36322x1

AS 08/02/08 (x8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2572

Saddle, Fwd, In



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Saddle, Fwd, In

Pick:

Qty	Part Number	Description	Batch
1	D2572	Saddle	B36323 AS 08/02/08 (X)

6.0

D2573

Saddle, Aft, Out



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Saddle, Aft, Out

Pick:

Qty	Part Number	Description	Batch
1	D2573	Saddle	B36324 x7 35933 x1 AS 08/02/08 (X)

7.0

D2574

Saddle, Aft, In



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Saddle, Aft, In

Pick:

Qty	Part Number	Description	Batch
1	D2574	Saddle	36325 AS 08/02/08 (X)

8.0

D27361

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Lug Assembly

Pick:

Qty	Part Number	Description	Batch
1	D2736-1	Bracket	31957 36330 AS 08/02/08 (X)

9.0

D27363

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Lug Assembly

Pick:

Qty	Part Number	Description	Batch
1	D2736-3	Bracket	35064 AS 08/02/08 (X)

Dart Aerospace Ltd

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Job Number:



Seq. #:

Machine Or Operation:

Description:

10.0

D2747

Set Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total: 32.0000 Each(s)

Set Screw

Pick:

Qty	Part Number	Description	Batch
4	D2747	Socket Head Set Screw	B36331 x17

AS 08/02/08 (X8)
35758 x15 all same Batch

11.0

D2876

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s)

Saddle Spacer

Pick:

Qty	Part Number	Description	Batch
2	D2876	Spacer	33543

AS 08/02/08 (X8)

12.0

D2877

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s)

Saddle Spacer

Pick:

Qty	Part Number	Description	Batch
2	D2877	Spacer	36276

AS 08/02/08 (X8)

13.0

D2968041

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Tow Ring

Pick:

Qty	Part Number	Description	Batch
1	D2968-041	Tow Ring	31957

AS 08/02/08 (X8)

14.0

D35331

Set Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s)

Set Screw

Batch:

28093

AS 08/02/08 (X8)

15.0

AN46A

Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total: 128.0000 Each(s)

Bolt

Pick:

M105810

AS 08/02/08 (X8)

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

Qty	Part Number	Description	Batch
16	AN4-6A	Bolt	

16.0

AN446A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

4

AN4-46A

Bolt

M106277

AS 08/02/08

(x8)

17.0

AN451A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

8

AN4-51A

Bolt

M10662 x 54
M105810 x 10

AS 08/02/08

(x8)

* All Same Batch

18.0

AN612A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

8

AN6-12A

Bolt

M106513 x33
M105558 x31

AS 08/02/08

(x8)

19.0

AN960JD416

Washer



Comment: Qty.: 32.0000 Each(s)/Unit Total : 256.0000 Each(s)

Washer

Pick:

Qty

Part Number

Description

Batch

32

AN960JD416

Washer

M106780

AS 08/02/07

(x8)

20.0

AN960JD616

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

Washer

Pick:

Qty

Part Number

Description

Batch

8

AN960JD616

Washer

M105906
M105906 x 13

* old batch not in computer

AS 08/02/07

(x8)

M106883 x 51

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: DD Date: 28/02/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0
HT

AN9704

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
1	AN970-4	Washer	105442

AS 08/02/07 (X8)

22.0
HT

MS21042L4

Nut



Comment: Qty.: 29.0000 Each(s)/Unit Total : 232.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
29	MS21042L4	Nut (or MS21042-4)	M105938

AS 08/02/07 (X8)

23.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT KITS 100% FOR COMPLETENESS

AS 08/02/07 (X8)

24.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PenH

AS 08/02/08 (X8)

25.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AS 08/02/10 (8)

Job Completion



2008/2/11 (8)

W

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED #	DRAWING NO. K10003	REV. C SHEET 1 OF 1
DATE 06.11.07		TITLE SADDLE KIT	SCALE NTS
A	00.06.01	NEW ISSUE	
B	00.11.22	ADD D2707-041 OPTION	
C	06.11.07	ADD D3533-1	

RELEASED

06.11.13 #

THIS KIT CONTAINS PARTS AND PAPERWORK APPLICABLE TO THE FOLLOWING SKIDTUBE AND SADDLE INSTALLATIONS:

AIRCRAFT	INSTALLATION
BELL 205/210/212/412	D205-634-011 D205-634-015
BELL 204	D204-635-011

THE FOLLOWING PARTS SHOULD BE USED PER THE RELEVANT DRAWINGS AND THE FOLLOWING TABLE (REF):

PART NUMBER	K10003	D205-634-011 D205-634-015	D204-635-011
D205-641-011	1	1	1
D2570	16	16	16
D2571	1	1	1
D2572	1	1	1
D2573	1	1	1
D2574	1	1	1
D2747	4	4	4
D2876	2	2	2
D2877	2	2	2
D2707-041 (or D2968-041)	1	1	1
D3533-1	2	2	2
AN4-51A	8	8	8
AN4-6A	16	16	16
AN6-12A	8	8	8
AN960JD416	32	32	32
AN960JD616	8	8	8
*AN960JD1016	1	1	1
AN970-4	1	1	1
MS21042-4 (OR L4)	25	25	25

* REQUIRED WITH D2707-041 ONLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36308

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